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Success with precision

Optimal conditions for the use of MNT Grinding Wheels

VS cutting speed m/s

We recommend a basic setting of 13–18 m/s.

m/s / Wheel ∅ mm	13	15	18
75	3'300	3'750	4'500 rpm
100	2'450	2'800	3'400
125	1'950	2'250	2'700
150	1'650	1'850	2'250

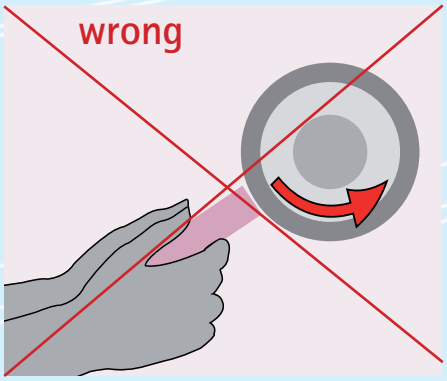
Qw' removal rate ($mm^3/mm/s$)

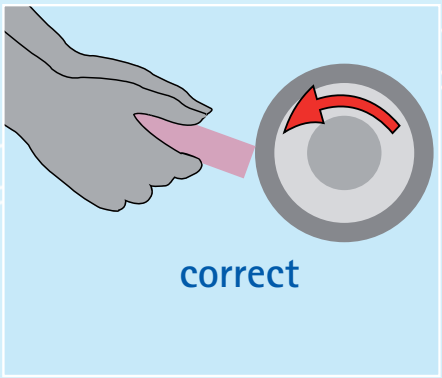
We recommend a basic setting of 4-5 mm3/mm/s.

Qw' / ae Infeed in mm	2.0	3.0	4.0	5.0	6.0
	Feed rate in mm/min				
2.0	60	90	120	150	180
2.5	50	70	95	120	145
3.0	40	60	80	100	120
3.5	35	50	70	85	100
4.0	30	45	60	75	90
4.5	25	40	55	65	80
5.0	20	35	50	60	70

Sharpening

Regular with sharpening stone no. 1 item no. 206226 (on the wheel flanks as well) improves the coolant transport and increases the removal rate.





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Cooling

It is only through the use of an optimal cooling medium that the MNT wheels can reach their full performance.

- Thin-flowing oil (max. 10 cst, low viscosity)
- Alternative emulsion with 3-4% additives
- Minimum pressure of 4 bar

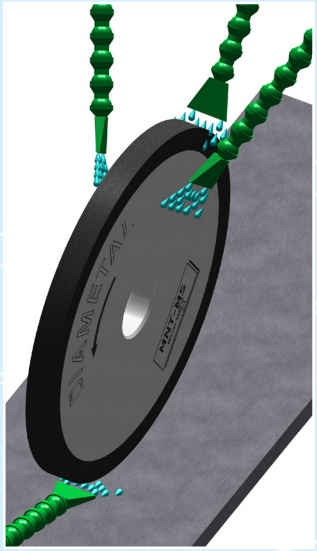
Filter system

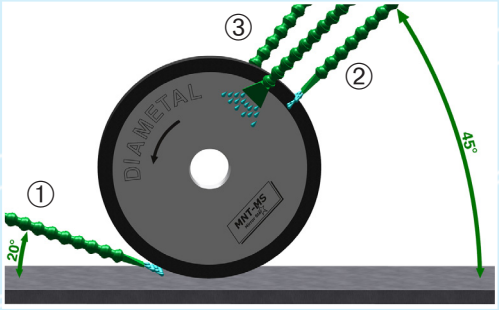
The contamination of the cooling medium can be prevented through the use of a good filter system.
We recommend:

- Centrifugal filter
- Edge filter
- Cooling unit on filter plant (coolant max. 28°C)

Cooling nozzle configuration

The efficiency of the MNT wheels can be optimised by the correct arrangement of the cooling nozzles.





① Main nozzle (grinding zone)
② Flushing nozzle
③ Wheel body cooling

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